

Work Order ID 47936

Friday, June 26, 2009 8:59:56 AM



Page 1

Item ID: D350-591-121

Accept



Setup Start



Revision ID: E

Stop



Item Name: Helix Access-Step, LH

Start Date: 7/15/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2351	Rev E								

100

0.00



DOCUMENT CONTROL

DC

Memo

Photocopy bluefile and type labels as per PPP D350-591-121CHG004

Document Control

110

0.00



Large Fab

Large Fab

Memo

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G 2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

B38023 x 4

Large Fab

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

Bend per Dwg D2351 using Bend Program D2351-041 FT011

CNC Delta 100 Bender

Use Bend Prog D2351-041

Macro/loc

9-7-8

(Pb) →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-591-121 PAR #: N/A Fault Category: Large Fab NCR: Yes No DQA: / Date: 09.07.22
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 05.08.24

NCR: <u>47936</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/26	120	Qty (4) Step (ALL) one over Bent. - two have cracks at the last rivet hole.	/esimur	Scrap and Destroy Qty x4 steps	/ 9-7-26	S 07/07/26	/esimur	S 07/07/26
		- two have the last rivet hole egged shape	/esimur	Replace Qty 4 B38623	SAD 09.07.07	S 07/07/26	/esimur	S 07/07/26
		R4 Bend was started @ wrong location 18 3/4" - 7/19"	/esimur				/esimur	S 07/07/26
		W400 Bend Program on w/o	/esimur				/esimur	S 07/07/26

NOTE: Date & initial all entries

[illegible]

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[illegible]

Abstract

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

[illegible]

Customer:

(b) (7)(C), (b) (7)(D)

[illegible]

Stop

**Insp.
Stamp**

$$\Rightarrow \delta o s b H o s \in \mathbb{C}$$

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and identifying the causes.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals have been met.

0.00

0.00

[illegible]

0.00

1-Bevel Fwd and Aft end for welding □ 2-Weld Aft End Bracket per QSI 004 &
Dwg D2351 using Welding Jig DT8033 □ A/RAluminum Rod 110972 □ 3-
Do not Grind Flush

0.00

[illegible]

0.00

Quality Control

Work Order ID 47936

Friday, June 26, 2009 8:59:56 AM



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Item ID: D350-591-121

Accept



Setup Start



Revision ID: E

Stop



Item Name: Heli-Access-Step, LH

Start Date: 7/15/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 802/7/09

(X)

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 09-07-13

(4)

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

H 09-07-13

(X4)

Work Order ID 47936

Friday, June 26, 2009 8:59:56 AM



Page 4

Item ID: D350-591-121

Accept



Setup Start



Revision ID: E

Stop



Item Name: Heli-Access-Step, LH

Start Date: 7/15/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Rivet Leg Assembly as per Dwg D2351								
200		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
210		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld Fwd End Plate per QSI 004 & Dwg D2351 <input type="checkbox"/> A/RAluminum Rod <u>M110130</u> <input type="checkbox"/> 2-Grind end cap flush per dwg D2351								

Work Order ID 47936

Friday, June 26, 2009 8:59:56 AM



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Item ID: D350-591-121

Accept



Setup Start



Revision ID: E

Stop



Item Name: Heli-Access-Step, LH

Start Date: 7/15/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

DD 0907-15 (4)

Quality Control

230

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

=> S 07/07/15 (4) f

Quality Control

240

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

umo 09/07/15 (4)

Hand Finishing

[illegible]

Friday, June 26, 2009 8:59:56 AM

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.

5. The final step is to evaluate the results of the project. This involves assessing the effectiveness of the plan and identifying any areas for improvement or further action.

(b) (7)(C), (b) (7)(D)

Abstract

Background: The purpose of this study was to determine whether there were differences in the prevalence of self-reported depression between men and women who had been exposed to violence during childhood.

Methods: Data from the National Longitudinal Study of Adolescent Health (Add Health) were used. This study included 9,800 adolescents aged 15–18 years who participated in a national survey in 1994–1996. Information about exposure to violence during childhood was obtained from parents or guardians. Depression was measured using the Center for Epidemiological Studies Depression Scale (CES-D).

Results: Results showed that exposure to violence during childhood was associated with higher rates of self-reported depression among both men and women. However, the association was stronger for women than for men.

Conclusions: These findings suggest that exposure to violence during childhood may have a more significant impact on mental health outcomes for women than for men.

Keywords: Violence, Depression, Gender, Adolescents

[illegible]

Customer:

[illegible]

**Insp.
Stamp**

[illegible]

9/7/17

[illegible]
$$\Rightarrow \int_{0.95/2}^{0.95/2}$$

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

9/7/20

Identify and pack for shipping as per PPP D350-691-
121 ☐ Location: 86 ☐ PPP Rev: E

121 ☐ Location: 86 ☐ PPP Rev: 3

Work Order ID 47936

Friday, June 26, 2009 8:59:56 AM



Page 8

Item ID: D350-591-121
Revision ID: E
Item Name: Heli-Access-Step, LH

Accept



Setup Start



Stop



Start Date: 7/15/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

310

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/22

MF 09.07.22

Picklist Print

Page 1

Friday, June 26, 2009 8:59:55 AM

Work Order ID: 47936

Parent Item: D350-591-121RevE

Parent Item Name: Heli-Access-Step, LH










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MS21042L4 <i>x3</i> 		Purchased	No		290 <i>118</i>		Each	0.0000	12.0000			
Nut												
✓ D2244-116RevD1 		Manufactured	No		110 <i>140</i>		Each	0.0000	2.0000			
Step Extrusion												
✓ D2582RevB 		Manufactured	No			190	Each	0.0000	4.0000			
Step Leg Assembly												
✓ D2850-1RevA 		Manufactured	No		140 <i>190</i>		Each	0.0000	4.0000			
End Bracket												
✓ MS20600-AD4W3 		Purchased	No		190	210	Each	0.0000	64.0000			
Cherry Rivets												
✓ AN3-37A <i>x2</i> 		Purchased	No			290	Each	0.0000	8.0000			
Bolt												
✓ AN4-13A <i>x3</i> 		Purchased	No			290	Each	0.0000	12.0000			
Bolt												
✓ AN960JD10 <i>x4</i> 		Purchased	No			290	Each	0.0000	16.0000			
Washer												
✓ AN960JD416 <i>x4</i> 		Purchased	No			290	Each	0.0000	24.0000			
Washer												

③ M110501 SP

B38023 → 5A109-0630

~~B38023~~ 47644 LE

B26919③ B31408 = 1 LE

M106375 LE

② M105425 SP

③ M111925 SP

④ M111668 SP

⑥ M111279 SP

④ 9/17/14

Picklist Print

Page 2

Friday, June 26, 2009 8:59:55 AM

Work Order ID: 47936



Parent Item: D350-591-121RevE



Parent Item Name: Heli-Access-Step, LH

Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2230-1RevF S2		Manufactured	No			290	Each	0.0000	4.0000	48289		SB
✗ Lug ✓ D2230-3RevF S2		Manufactured	No			290	Each	0.0000	4.0000	47965		SB
✗ Lug ✓ D2673-34RevB S2		Manufactured	No		210	290	Each	0.0000	4.0000	336406		fh
End Plate ✓ D2856-400RevA S2		Manufactured	No			290	f	0.0000	2.4000	46543		CU
✗ Abraison Strip MS21042L3 S1		Purchased	No			290	Each	0.0000	8.0000	M111274		SEP
✗ Nut											9/7/17	

45

L

Date: Wednesday, 13/05/2009 11:29:15 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT STEP ASSEMBLY
Job Number	: 47936		
Estimate Number	: 11672		
P.O. Number	:	Part Number	: D350591121
This Issue	: 13/05/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2351 UNDER REVIEW <i>6.05.13</i>
First Issue	: / /	Project Number	: N/A
Previous Run	: 47623	Drawing Revision	: E
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 29/05/2009
Checked & Approved By	: <i>JW 09.05.13</i>	Qty:	4 Um: Each
Comment	: Est Rev: E 02.10.21 Re-format; Incorporated D2351-041 IPP K J/RF est rev. F 06.02.23 added grinding EC Est Rev: G 09.05.06 Update comment on step 4 KJ Verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 ✓ DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-121CHG004

2.0 ✓ D2244116

Step Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

0.5 D2244-116 Extrusion *B38023**SAD 09-06-30**(4)*

3.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

*SAD 09-06-30**(4)*

4.0 BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041.

SAD 09-07-8

Date: Wednesday, 13/05/2009 11:29:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 47936

Part Number: D350591121

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/07/08 (CY)

6.0	D28501	End Bracket
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2850-1	End Bracket	326919

H 09-07-09 4

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Fwd and Aft end for welding

2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033

A/R Aluminum Rod M110130
M110972

3-Do not Grind Flush

H 09-07-09 4
H 09-07-10 4
H 09-07-10 4

8.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

BE 09-07-10 4

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/07/09

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H 09-07-10 4

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

H 09-07-14 4

Date: Wednesday, 13/05/2009 11:29:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 47936

Part Number: D350591121

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D2582	Step Leg Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2582	Step Leg Assy	B47644
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Handwritten signature 09.07.14

4

13.0	MS20600AD4W3	Cherry Rivets
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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16	MS20600AD4W3	Rivet	M106375
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4

14.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Rivet Leg Assembly as per Dwg D2351

Handwritten signature 09.07.14

4

15.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Handwritten signature 07/07/14

16.0	D267334	End Plate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2673-34	End Plate	B36406
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Handwritten signature 09.07.14

4

17.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd End Plate per QSI 004 & Dwg D2351

A/R Aluminum Rod M110130

2-Grind end cap flush per dwg D2351

Handwritten signature 09.07.14

4

Handwritten signature 09.07.14

4

Date: Wednesday, 13/05/2009 11:29:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 47936

Part Number: D350591121

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11 09-07-15

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/07/15 (x9)

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

UMD 09/07/15 (x4)

21.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M112148
Pressure wash

UMD 09/07/15 (x4)

START TIME:

1:50pm

OVEN TEMPERATURE:

320°C

FINISH TIME:

2:20pm

gl

09-07-15

(x4)

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk per Dwg D2351 and QSI 005 4.4

Batch: M111013

UMD 09/07/16 (x4)

23.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-07-16 (4)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9/7/20

SV

(4)

25.0

D22301

Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Packing Kit Qty Part Number Description Batch

Date: Wednesday, 13/05/2009 11:29:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 47936

Part Number: D350591121

Job Number:



Seq. #: Machine Or Operation: Description :

1 D2230-1 Mounting Lug _____

26.0 ✓ D22303 Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

1 D2230-3 Mounting Lug _____

27.0 ✓ D2856400 Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 2.4000 f(s)

Pick:

Packing KitQty Part Number Description Batch

1 D2856-400 7.20" Abrasion Strip _____

28.0 ✓ AN337A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

2 AN3-37A Bolt _____

29.0 ✓ AN413A Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

AN4-13A

Batch: _____

30.0 ✓ AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

4 AN960JD10 Washer _____

31.0 ✓ AN960JD416 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

6 AN960JD416 Washer _____

Date: Wednesday, 13/05/2009 11:29:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 47936

Part Number: D350591121

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

✓ MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

2 MS21042L3 Nut (or -3) _____

33.0

✓ MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

3 MS21042L4 Nut (or -4) _____

34.0

✓ QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

504/07/21 (x4)

35.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-121

Location: _____

PPP Rev: _____

36.0

✓ QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion ✓



DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

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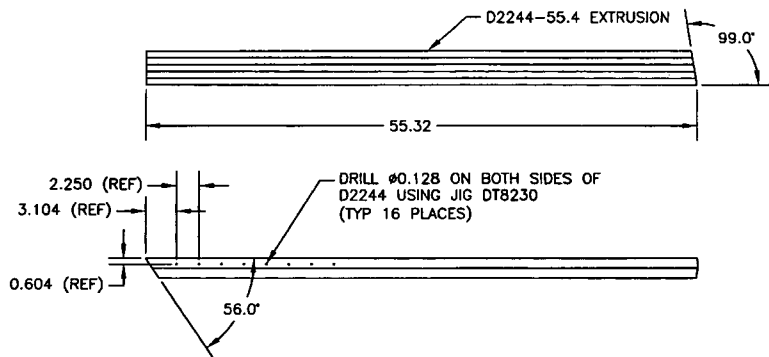
RELEASED
05.11.28

PH
ECN 1105
UNDER REVIEW
07.11.14
PER 1105 263

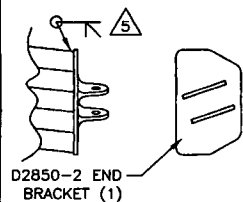
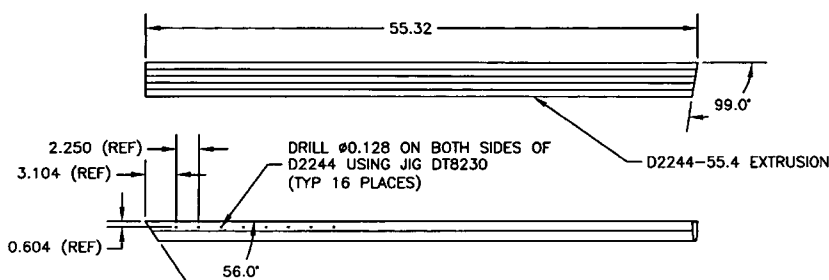
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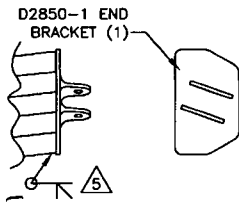
D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP



D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP



DETAIL A
SCALE: 1:4

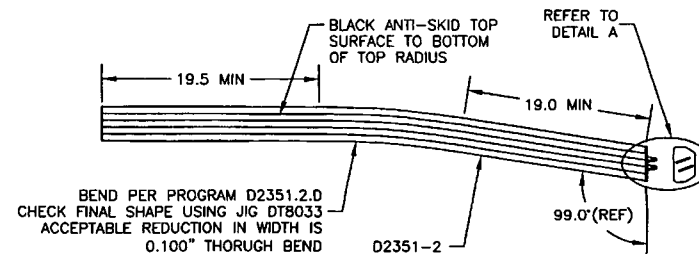


DETAIL B
SCALE: 1:4

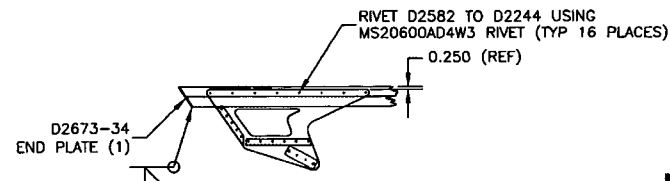
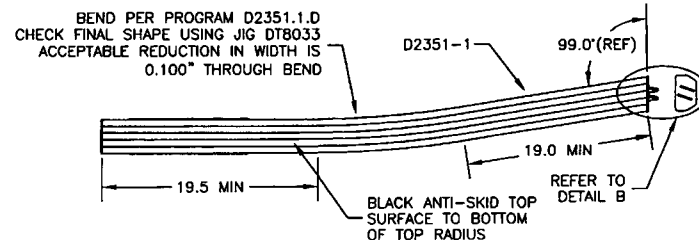
D2582 STEP LEG ASSEMBLY (1)



D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP



D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



GENERAL NOTES

- 1) WELD PER DART QSI 004
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- CHAMFER D2244 EXTRUSION 0.075"x45' BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

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DESIGN KE	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E
DATE 05.11.14	TITLE HIGH FLOAT STEP ASSEMBLY	SHEET 2 OF 2	SCALE 1:12